

# Work Order ID 83009

Thursday, April 12, 2012 11:17:52 AM

\*83009\*

Page 1

Item ID: D3436-044 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Step RH  
 Start Date: 4/12/2012 Start Qty: 3.00 \*3\* Cust Item ID:  
 Required Date: 4/24/2012 Req'd Qty: 3.00 \*3\* Customer:  
 Reference:

Approvals: Process Plan: D Date: 12-04-12 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3436	Rev A								

100

0.00

\*100\*

Large Fab

Large Fab

0.00

Large Fab

## Memo

Weld bushings D3436-5 and clamp D3436-1 using welding Jig DT8772 and

Dwg D3436Dwg Rev: A

Qty Part Number Description Batch

A/RN/A 4130 Welding Rod M 118875

Weld right step D3436-4 using welding Jig DT8773 and Dwg D3436Dwg

Rev: A

Qty Part Number Description Batch

A/RN/A 4130 Welding Rod M 118875

Weld cap D3436-7 as per Dwg D3436Dwg Rev: A

Qty Part Number Description Batch

A/RN/A 4130 Welding Rod M 118875

3 EL 12-4-17

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 83009

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**\*83009\***

Page 2

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 Required Date: 4/24/2012 Req'd Qty: 3.00 **\*3\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 <b>*110*</b> Bandsaw Jeaspa Bandsaw	BAND SAW  Memo 1-Slit part D3436-041 on bandsaw as per Dwg D3436 2- deburr	0.00  0.00				3		02	12-4-17
120 <b>*120*</b> QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds  Memo	0.00  0.00				3x	Ø		6/20/18
130 <b>*130*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00				73 RH	P		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*83009\***

Thursday, April 12, 2012 11:17:52 AM

**\*N900040100\***

**Setup Start \*NS1\***

Stop **\*NS2\***

**\*3\***

\*3\*

**Reference:**

Run Start \*NR1\*

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**\*140\***

Wing Walk as per dwg QSI005 4.4 Batch 7707800 0.00

**\*145\***

## Wing Walk B

**\*150\***

## Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Thursday, April 12, 2012 11:17:52 AM

**\*83009\***

Page 4

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 4/12/2012      **Start Qty:** 3.00      **\*3\***

**Cust Item ID:**

**Required Date:** 4/24/2012      **Req'd Qty:** 3.00      **\*3\***

**Customer:**

**Reference:**

Run Start \*NR1\*

**Approvals:**      **Process Plan:**                      **Date:**                      **Tooling:**                      **Date:**

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Insp.  
Stamp**

0.00

**\*155\***

### Small Fab

## Memo

0.00

## Small Fab

Bond pads per dwg and QSI 015

160

QC5- Inspect part completeness to step on W/O

0.00

**\*160\***

QC

## Memo

0.00

## Quality Control

170

Identify as per dwg & Stock Location: 203

0.00

**\*170\***

### Packaging

## Memo

0.00

## Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 4/12/2012      **Start Qty:** 3.00      **\*3\***

**Cust Item ID:**

**Required Date:** 4/24/2012      **Req'd Qty:** 3.00      **\*3\***

**Customer:**

Run Start \*NR1\*

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Insp.  
Stamp**

0.00

**\*180\***

QC

## Memo

0.00

## Quality Control

P12-04-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Thursday, April 12, 2012 11:17:57 AM

Page 1

Work Order ID: 83009

\*83009\*

Parent Item: D3436-044

\*D3436-044\*

Parent Item Name: Step RH

Start Date: 4/12/2012

Required Date: 4/24/2012

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP A 05.05.11New IssueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3436-5		Manufactured	No			100	Each	48.0000	4	12			
<b>*D3436-5*</b> Bushing													

Location	Loc Qty	Loc Code
ST044	44	
46592	20	
82071	24	
WA024	4	
75229	4	

\*\* EL 12-4-16

12-

D3436-7		Manufactured	No			100	Each	35.0000	1	3			
<b>*D3436-7*</b> Cap													

Location	Loc Qty	Loc Code
WA021	35	
56836	35	

\*\* EL 12-4-17

3

D3436-9		Manufactured	No			100	Each	8.0000	2	6			
<b>*D3436-9*</b> Pad													

Location	Loc Qty	Loc Code
GA 82172	8	
79670	4	
80244	4	

\*\* (3)

FF 12-04-20

4

2

D3436-4		Manufactured	No			100	Each	3.0000	1	3			
<b>*D3436-4*</b> Right Step													

Location	Loc Qty	Loc Code
WA022	3	
73545	3	

\*\* EL 12-4-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 2

Work Order ID: 83009

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Parent Item: D3436-044

\*D3436-044\*

Parent Item Name: Step RH

Start Date: 4/12/2012

Required Date: 4/24/2012

Start Qty: 3.00

Required Qty: 3.00

D3436-1

Manufactured No

155

Each

33.0000

1

3

\*D3436-1\*

\*\*

Clamp

12-4-17

Location

Loc Qty

Loc Code

WA024

33

17679

33

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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CHECKED H	APPROVED H	DRAWING NO. <b>D3436</b>	REV. A SHEET 1 OF 4
DATE <b>05.04.28</b>	TITLE <b>MAINTENANCE STEP</b>		SCALE 1:4
A	05.04.28	NEW ISSUE	

SHOP COPY

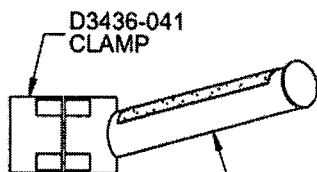
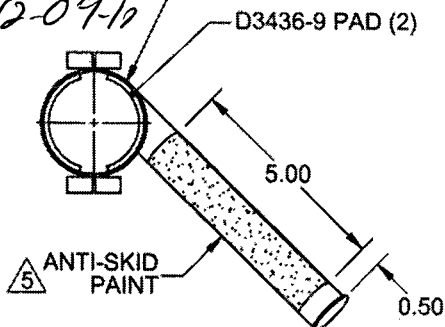
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. **83009**

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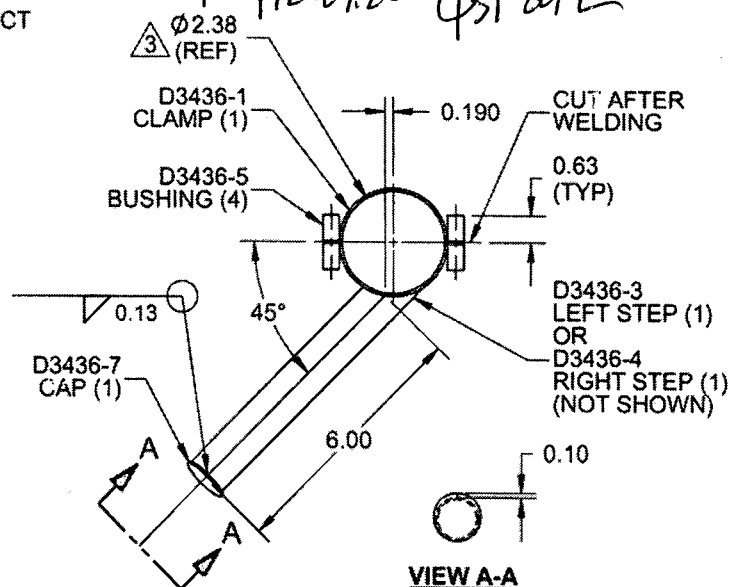
*Rubber + Insulated ad Reson 130DL*

*OK 12.04.20 QSI dnr*

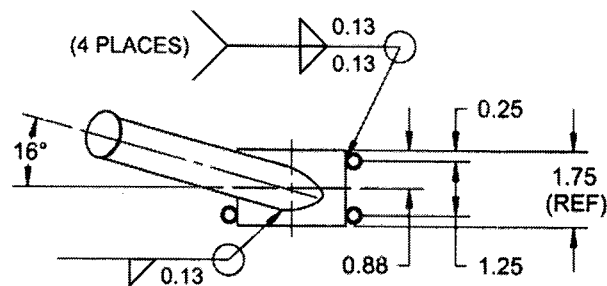
BOND WITH CONTACT  
CEMENT PER  
MANUFACTURER'S  
SPECIFICATION  
(2 PLACES)



D3436-043, LH STEP  
D3436-044, RH STEP  
(NOT SHOWN)



VIEW A-A



WELDING

NOTES:

- 1) POSITION PARTS AS PER JIGS DT8772 AND DT8773
- 2) WELD PER DART QSI 004
- 3) FILLET BOTH TOP AND BOTTOM EDGES OF CLAMP ALONG 2.38 I.D. SECTION TO 0.03 RADIUS TO PREVENT SCORING AND SCRATCHING OF SKID CROSS TUBE
- 4) FINISH: POWDER COAT WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3
- 5) APPLY BLACK ANTI-SKID PAINT AS SHOWN PER DART QSI 005 4.4
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

RELEASED

05.05.27

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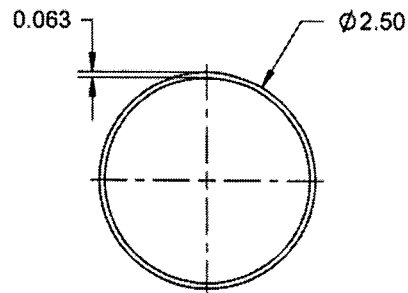
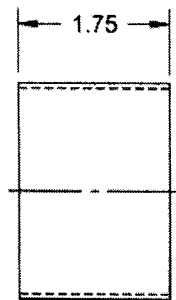
**NOTE:** Date & initial all entries





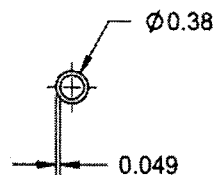
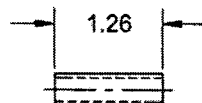
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CHECKED H	APPROVED H	DRAWING NO. <b>D3436</b>	REV. A SHEET 2 OF 4
DATE <b>05.04.28</b>	TITLE <b>MAINTENANCE STEP</b>		SCALE 1:2

83009



#### **D3436-1 CLAMP**

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T2500W063)



#### **D3436-5 BUSHING**

- 2) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T0375W049)

RELEASED

05-05-27 H

#### **D3436-1/-5, GENERAL NOTES:**

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) ALL DIMENSIONS ARE IN INCHES  
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

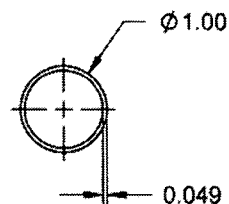
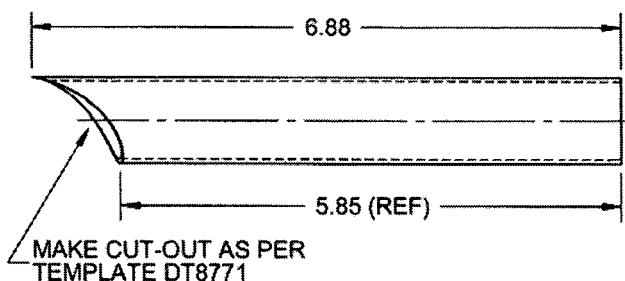
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3436	REV. A SHEET 3 OF 4
DATE 05.04.28	TITLE MAINTENANCE STEP		SCALE 1:2

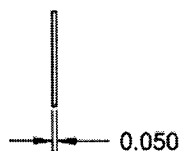
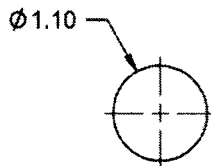
83009



**D3436-3 LEFT STEP**

(D3436-4 RIGHT STEP - OPPOSITE, NOT SHOWN)

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T1000W049)



**D3436-7 CAP**

- 2) MATERIAL: AISI 4130N STEEL SHEET PER MIL-S-18729, AMS6350 OR AMS 6351 (REF. DART SPEC. M4130N-S050)

RELEASED

05-05-27 *[Signature]*

**D3436-3/-7, GENERAL NOTES:**

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) ALL DIMENSIONS ARE IN INCHES  
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

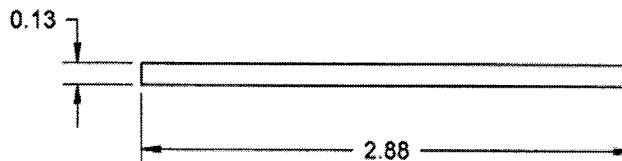
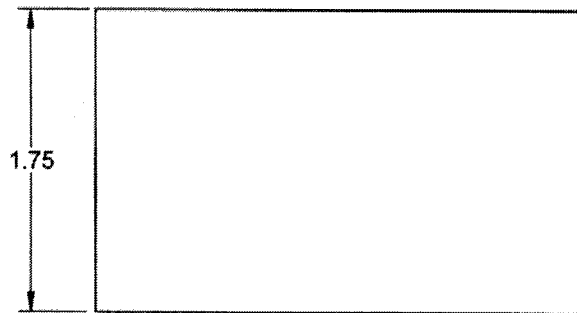
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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CHECKED <i>MB</i>	APPROVED <i>MB</i>	DRAWING NO. <b>D3436</b>	REV. A SHEET 4 OF 4
DATE <b>05.04.28</b>		TITLE <b>MAINTENANCE STEP</b>	SCALE 1:1

83009



RELEASED

05.05.27 *MB*

**D3436-9 PAD**

**NOTES:**

- 1) MATERIAL: 60 DUROMETER NEOPRENE SHEET, 1/8" THICK  
(REF. DART SPEC. M-NEO60-S.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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# Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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